Wednesday, 07/03/2007 12:37:20 PM

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Dart Aerospace Ltd.

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 31052

Linda Lacelle

Estimate Number P.O. Number

: 12523 : NIA

This Issue

: 07/03/2007

S.O. No. : NIA

Prsht Rev. : NC

: MA First Issue

: 28425 **Previous Run**

Written By Checked & Approved By

Comment

Type

: Est Rev:A New Issue 06-09.06 EC

: SMALL /MED FAB

Drawing Number Project Number

Drawing Name

Part Number

: N/A : N/A

: BRACKET ASS'Y

· UNDER REVIEW

: D35313

Drawing Revision : NA **Material**

: 09/03/2007 **Due Date**

Qtv:

1 Um: Each

Additional Product

Job Number:



Seq. #:

Description: 6061-T6 .040 Sheet

1.0 M6061T6S040

Comment: Qty.:

0.1379 sf(s)/Unit

Total: 0.1379 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M 19380

M100742 M 070309

Comment: FLOW WATER JET 1-Cut as per Dwg D3531

Dwg Rev: し R

Prog Rev: UR

M 07 03 09 M 07 03 08

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



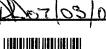
Comment: SECOND CHECK

5.0

3.0

SMALL FAB

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

Wednesday, 07/03/2007 12:37:21 PM Date: }∮šer: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BRACKET ASS'Y Job Number: 31052 Part Number: D35313 Job Number: Seq. #: Description: **Machine Or Operation:** 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE Bend as per Dwg D3530 HAND FINISHING RESOURCE #1 HAND FINISHING1 7.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1 Identify and Stock Location: SINGE

QC21

10.0

Job Completion

Comment: FINAL INSPECTION/W/O RELEASE

1 57.03.12

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DART AEROSPACE LTD	Work Order:	31052
	Part Number:	73531-3
Description: Brachet Assy	· ·	Same 1 of 1
Inspection Dwg: UR Rev: UR		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

• ••	-	First Article	-	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	lujest	Method of Inspection	Comments
\$ 0.129	+0.005-0.001	0.133	V		vern	
2.840	+1-0.010	2.840	√		VarN	
0.710	+1-0.010	0.708	V		VerN	
4.67	+1-0.030	4.67	1		New	
3.50	+1-0.030	3.500	\/		VECN	,
3.57	+1-0.030	3.574	<u> </u>		VLVN	
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Measured by: M. M	Audited by:	Prototype Approval:
Date: 07.02.08	Date: 07/03/08	Date:
10:0308	10//02/4/8	Davised by Approve

	D - 4-	Chan	Revised by Approved
Rev	Date	Change	
A		New Issue	KJ/JLM
1 ' '	1.		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES							
DATE	STEP	PROCEI	PROCEDURE CHANGE					Approval QC Inspector
ल्या ⁶³ क्ष	61	Qc 5 inspection	permenent charge	by	<i>७५०</i> ४००		1670309	01030

Part No: ______ PAR #: ____ Fault Category: ______ NCR: Yes No DQA. ____ Date: 01/03/13

QA: N/C Closed: ____ Date: ____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
07/03/09	٥, ي	-bending is out of tol by 0.080"	POSIOUR	-destroy part and replace	M 07 03 09	Moslog	1051042	2/3/09
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 31052	
Description: Bracket Ass'n	Part Number: 03531-3	-
Description. Stacker 1195	5-1011	_
Inspection Dwg: 10/R Rev: U/R	. Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

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Drawing Dimension	Tolerance	Actual Dimension	Accept	lejest	Method of Inspection	Comments
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4.67	+-0.030	4.679	\		vern	
3.50	4-0.030	3.512	1		VerN	
3.57	H-0.030	3.575	1		Vern	
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Measured by:	ml. nd	Audited by:	Prototype Approval:
Date:	070309	Date: 07/03/09	Date:
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Rev	Date	Change	Revised by Approved
Α		New Issue	KJ/JLM

